

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68250

Monday, April 11, 2011 10:28:57 AM



Page 2

Item ID: D3492-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Plug Assembly

Start Date: 4/11/2011 Start Qty: 120.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 120.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Deburr if necessary <input type="checkbox"/> 2-Tumble								
		0.00							
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC 	Memo	0.00							
Quality Control									
150 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish 	Memo	0.00							
Hand Finishing									

MAS

120 of 140 of 18

W/O:		WORK ORDER CHANGES						
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Work Order ID 68250

Monday, April 11, 2011 10:28:57 AM

Page 3

Item ID: D3492-041

Accept

Revision ID:

Item Name: Plug Assembly

Start Date: 4/11/2011 Start Qty: 120.00

Required Date: 4/14/2011 Req'd Qty: 120.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

(Flat End Only) ☐ START TIME: 1:55 ☐ OVENTEMPERATURE: 320 ☐ FINISH TIME: 2:25

120 BR 11-4-18

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

120 φ 11-4-18

180

Identify as per dwg & Stock Location: FP-13

0.00



Packaging

Memo

0.00

Packaging

120 φ 11-4-18

W/O:		WORK ORDER CHANGES						
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Work Order ID 68250

Monday, April 11, 2011 10:28:57 AM



Page 4

Item ID: D3492-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Plug Assembly

Start Date: 4/11/2011 Start Qty: 120.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 120.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

4/14/11

11-04-18
120

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

Picklist Print

Monday, April 11, 2011 10:29:11 AM

Page 1

Work Order ID: 68250



Parent Item: D3492-041



Parent Item Name: Plug Assembly


Start Date: 4/11/2011

Required Date: 4/14/2011

Start Qty: 120.00

Required Qty: 120.00

Comments: IPP rev A 06.03.03 New Issue EC
IPP Rev:B 06-08-28 As per Rev B JLM
IPP Rev:C 07-12-06 Rev C dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.625 		Purchased	No			100	f	59.6000	0.0625	7.894737		<i>ml 11.4.14</i>	
6061-T6 Round Bar .625"													

Location

MAT012

117284 ✓

Loc Qty

59.6

59.6

Loc Code

6.6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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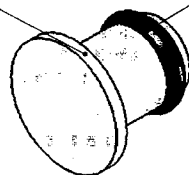
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NOTE: Date & initial all entries

D3492-XX PLUG
(SEE TABLE)

NAS1611 PLUG
(SEE TABLE)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68250

pl 11-04-4

D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
				1	1		NAS1611-015	O-RING
							NAS1611-016	O-RING

△ △ △

NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

UNDER REVIEW

02.04.21
OK ASS 08.11.12

DEO ATTACHED

RELEASED
01.11.16

C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>PH</i>	D3492	SHEET 1 OF 2
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	PLUG	2:1
DATE	07.10.05	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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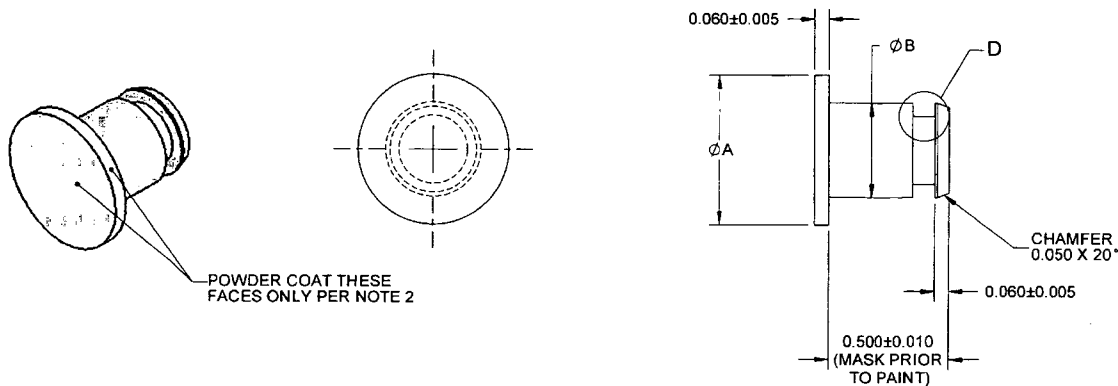
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

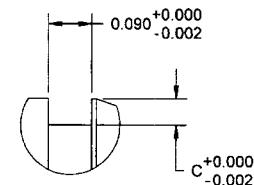
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



POWDER COAT THESE
FACES ONLY PER NOTE 2



DETAIL D

D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

W/0 68250

UNDER REVIEW

03.07.11
05.08.11
07.11.12
OK

DEO ATTACHED

RELEASED
07.11.12

DESIGN	<i>RA</i>	DART AEROSPACE LTD	
DRAWN	<i>RA</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RA</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>RA</i>	D3492	SHEET 2 OF 2
APPROVED	<i>RA</i>	TITLE	SCALE
DE APPR.	<i>RA</i>	PLUG	4:1
DATE	07.10.05	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

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NOTE: Date & initial all entries

DRAWING NO. D3492	TITLE PLUG	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3492-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR. <i>B</i>	APPROVED <i>MP</i>		DE APPR. <i>MP</i>		
DATE 08.11.05	DATE 08.11.05	DATE 08.11.05	DATE 08/11/05		DATE 08/11/05		

SHEET 2 MODIFY -13 PLUG AS SHOWN:

IS:

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.510	0.045	M6061T6R0.750

u1045250

WAS:

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.520	0.045	M6061T6R0.750

RELEASED
08/11/10 *MP*

W/O:		WORK ORDER CHANGES						
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